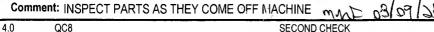
Each

Monday, 08/09/2008 2:50:48 PM

User: Julie Lecocq **Process Sheet** : TUBE Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 41891 **Estimate Number** : 11172 : D22827 P.O. Number **Part Number** : 08/09/2008 S.O. No. : **Drawing Number** . D2282 REV E This Issue : N/A Prsht Rev. : NC Project Number : // ; E First Issue : MACHINED PARTS Type **Drawing Revision** : 39818 **Previous Run** Material **Due Date** : 30/10/2008 Qty: 200 Um: Written By Checked & Approved By Comment 05-12-02 JLM Removed from 9 Digit : Est Rev:A **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: M304TR0675W091 1.0 304 RD Tube .675 x .091W Comment: Qty.: 0.0699 f(s)/Unit Total: 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) Batch M109366 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190 2-Deburr 3.0 QC2







Comment: SECOND CHECK PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:





5.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	TE STEP PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
-										
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Part No:	PAR #:	Fault Category	:	NCR: Yes No	DQA:	Date:
Resolu	ion:	Disposition:	,	QA: N/C Closed	d:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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NOTE: Date & initial all entries

Date:

Monday, 08/09/2008 2:50:49 PM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 41891

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/10/08 HJ

Dart Aerospace Ltd

W/O:	r:	1	WC	RK ORDER CHANGES				4	
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Part No):	PAR #:	Fault Cate	gory: N	ICR: Yes	No DQ	A :	Date:	
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NCR:			WORK ORDI	CE (NCI	₹)				
DATE	STEP	Description of NC		Corrective Action Section B		0 1	cation	Approval	Approval
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4	
Description: Handle Tube	Part Number: D228	2-7
Inspection Dwg: D2282 Rev: E	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

	х	First Article	Pro	totype
_		4		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	.794	V			
0.493	+/-0.010	.493	J ,			
0.675	+/-0.010	672	J	18-2		
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Measured by:	mont,	Audited by:	Prototype Approval:	N/A
Date:	8/09/28	Date: 05/10/03	Date:	N/A

Date	Change	Revised by	Approved
03.11.11	New Issue P/O D350-615-041	KJ/RF	
05.04.19	0.795 was 0.750	KJ/JLM	
06.03.15	Dwg Rev update	KJ/JLM	
07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM	B
	03.11.11 05.04.19 06.03.15	03.11.11 New Issue P/O D350-615-041 05.04.19 0.795 was 0.750 06.03.15 Dwg Rev update	03.11.11 New Issue P/O D350-615-041 KJ/RF 05.04.19 0.795 was 0.750 KJ/JLM 06.03.15 Dwg Rev update KJ/JLM

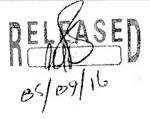


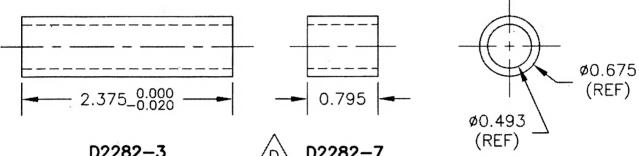
DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED):O	APPROVED	DRAWING NO. REV. E
	w	1/40	D2282 SHEET 1 OF 2
DATE	***************************************		TITLE SCALE
05.0	6.07		HANDLE TUBES 1:1
A		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030

UNCONTROLLED COPY SUBJECT TO AMENDMENT

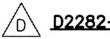
WITHOUT NOTICE

NO.





D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP $0.090 \times 45^{\circ}$ 0.95 -CHAMFER 0.158 Ø0.700 R0.350 -Ø0.386 0.125 $0.080 \times 45^{\circ}$ (REF) **CHAMFER** 2.17 **SHOP COPY RETURN TO ENGINEERING** D2282-5

D2282-5 STEM:

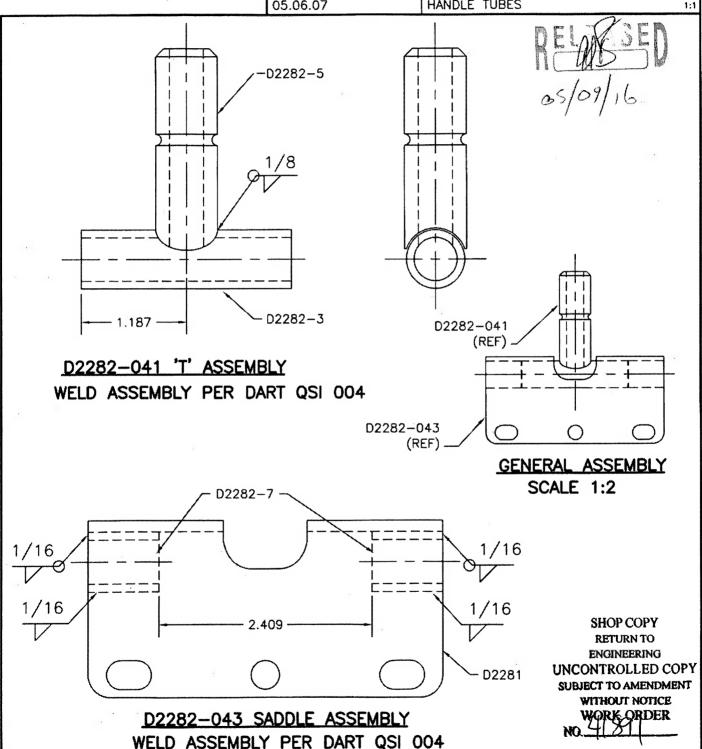
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Cì	HECKED . /	APPROVED	DRAWING NO.		REV.	Ε
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I٥	5.06.07		HANDLE TUBES			1:1



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